



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2891-1
Job Sheet 208452



DAS
21
9-08

Part No: D2891-1

Job Qty: 24 pcs

Part Name: Support 2.25



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/20/20

Job Tracking No:

Due Date: 4/13/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D2891 REV C IPP C 08.03.19 Re-format EC verified:DD/IPP Rev:E 11.08.04 as per dwg rev.B DD
verf:EC/IPP Rev.F 19.12.02 drawing revision DP Verify DD

Ship Via:

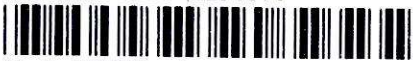
Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	24 pcs	4/13/20		1.00	19.67	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	QC 2	24 pcs	4/13/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		



Container No: S271577



Part: D2891-1

Job No: 208452

Serial No/Batch: S271577

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/17/20

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				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
120	QC 8	24 pcs	4/13/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
130	Crosstubes - 2 - B4B	24 pcs	4/13/20	0.00 1.13	Crosstubes - 1 - B4B
					Crosstubes - 2 - B4B
					Crosstubes - 3 - B4B
					Crosstubes - 4 - B4B
140	QC 3	24 pcs	4/13/20	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9

QC 8 - 49 *QC 8 - 49 20/04/18*

Crosstubes - 3 - B4B *DAS*
 Crosstubes - 4 - B4B *41 APR 18 2020*

3-89

					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	DAS
					QC 3 - 61	82
					QC 3 - 81	9-89
					QC 3 - 82	APR 1 0 2020
170 Packaging 3-1 - Stock - B4B 24 pcs	4/13/20	0.00	0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B		
				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B	DAS	
				Packaging 3 - 22 - B4B	41	APR 2 0 2020
				Packaging 3 - 23 - B4B	9-89	
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
				Packaging 3 - 37 - B4B		
180 QC 21 - SA	24 pcs	4/13/20	0.00	0.00	QC 21 - SA - 21	APR 2 0 2020
					QC 21 - SA - 70	DAS
					QC 21 - SA - 53	21

Part Op 100 - HAAS CNC Vertical Machine - 1-Machine as per Folio FA046

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Crosstubes - Per note 8 on page 1 of dwg D2891, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24H of cure time. 5206999 exp 8/21

140 - QC3- Inspect Part Finish

170 - Identify as per dwg & Stock Location 16050 LOCATION : LG052

180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK076	D2891-1 Turning Detail	12 pcs (.5 ea)	100-HAAS 4 Axis	S251416

Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-HAAS 4 Axis	DSK076	12	28	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.250 Support	0.188Inches ± 0.000	0.000 0.188		
2	2.250 Support	0.240Inches ± 0.000	0.000 0.240		
3	2.250 Support	0.115Inches ± 0.000	0.000 0.115		
4	2.250 Support	0.040Inches ± 0.000	0.000 0.040		
5	2.250 Support	0.010Inches ± 0.000	0.000 0.010		
6	2.250 Support	0.240Inches ± 0.000	0.000 0.240		
7	2.250 Support	0.290Inches ± 0.000	0.000 0.290		
8	2.250 Support	0.115Inches ± 0.000	0.000 0.115		
9	2.250 Support	0.454Inches ± 0.000	0.000 0.454		
10	2.250 Support	2.779Inches ± 0.000	0.000 2.779		
11	2.250 Support	0.240Inches ± 0.000	0.000 0.240		
12	2.250 Support	1.002Inches ± 0.000	0.000 1.002		
13	2.250 Support	0.053Inches ± 0.000	0.000 0.053		
14	2.250 Support	0.257Inches ± 0.000	0.000 0.257		
15	2.250 Support	1.663Inches ± 0.000	0.000 1.663		
16	2.250 Support	0.053Inches ± 0.000	0.000 0.053		
17	2.250 Support	0.022Inches ± 0.000	0.000 0.022		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order:	
Description: Ø2.250 Support		Part Number:	D2891-1
Inspection Dwg: D2891	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.188	0.193		.190	.19	.19	.19	.19
AB	0.240	0.260		.247	.248	.25	.251	.252
AC	0.115	0.150		.126	.124	.128	.127	.124
AD	0.040	0.060		.046	.048	.05	.049	.05
AE	0.010	0.020		.01	.01	.01	.01	.01
AF	R 0.240	0.260		R.25	R.25	R.25	R.25	R.25
AG	0.290	0.310		.3	.3	.3	.3	.3
AH	0.115	0.150		.14	.14	.14	.14	.14
AI	0.454	0.474		.462	.462	.458	.457	.463
AJ	2.779	2.789		2.784	2.786	2.786	2.786	2.786
AK	R 0.240	0.260		R.25	R.25	R.25	R.25	R.25
AL	1.002	1.042		1.036	1.036	1.034	1.038	1.034
AM	R 0.053	0.073		R.063	R.063	R.063	R.063	R.063
AN	0.257	0.262		.259	.259	.259	.259	.259
AO	1.663	1.683		1.676	1.675	1.675	1.673	1.677
AP	R 0.053	0.073		R.063	R.063	R.063	R.063	R.063
AQ	R 0.022	0.042		R.032	R.032	R.032	R.032	R.032
AR								
AS								
AT								
Accept/Reject								

Measured by: <i>AC</i>	Date: <i>20/04/17</i>
Audited by: <i>mmc</i>	Date: <i>20/04/18</i>
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	
Description: Ø2.250 Support		Part Number:	D2891-1
Inspection Dwg: D2891		Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	#6	2	3	4	5
HAAS Section								
AA	0.188	0.193		.19				
AB	0.240	0.260		.247				
AC	0.115	0.150		.124				
AD	0.040	0.060		.051				
AE	0.010	0.020		.01				
AF	0.240	0.260		R.25				
AG	0.290	0.310		.3				
AH	0.115	0.150		.14				
AI	0.454	0.474		.462				
AJ	2.779	2.789		2.786				
AK	0.240	0.260		R.25				
AL	1.002	1.042		1.036				
AM	0.053	0.073		R.063				
AN	0.257	0.262		.259				
AO	1.663	1.683		1.676				
AP	0.053	0.073		R.063				
AQ	0.022	0.042		R.032				
AR								
AS								
AT								
Accept/Reject								

Measured by: <i>De</i>	Date: <i>20/04/17</i>
Audited by: <i>mmL</i>	Date: <i>20/04/18</i>
Preliminary Approval:	Date:

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